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WAR FOOD ADMINISTRATION  
Office of Distribution  
Washington 25, D. C.

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SPECIFICATIONS FOR NAILED WOOD BOXES

Size: Approximately - 15" x 15" x 24" - Inside Dimensions - Upright

Wood boxes to hold approximately 120 pounds of product shall be made of new materials and of good commercial quality. These specifications do not prevent the manufacturer using heavier material or nails. All boxes shall be made of seasoned lumber having a moisture content not to exceed 18%. The pieces shall show no defects that materially weaken or expose the contents of the box to damage, or interfere with the nailing. No knot shall have a diameter exceeding 1/3 of the width of the piece. The surface of the box parts shall be sufficiently smooth to permit legible stenciling and shall not be splintery. The box sections shall be tongued and grooved with no piece less than 2-1/2 inches wide. Boxes shall be of style 4 construction, with cleats 1-3/4 inches wide and following thickness of the end:

Minimum Finished Thickness of Ends		Minimum Finished Thickness Sides, Top and Bottom	
Group I or II Woods	Group III or IV Woods	Group I or II Woods	Group III or IV Woods
13/16 inch	3/4 inch	1/2 inch	3/8 inch

Nailing through sides, top and bottom to ends and cleats shall be with six-penny nails spaced not more than 2-1/2 inches apart. On nailing sides to ends and cleats at least half of nails are to be driven through sides into cleats attached to ends. Cleats to be attached to ends with nails long enough to provide a satisfactory clinch.

The nailed boxes shall be reinforced by two flat straps 3/8 x .020 with tensile strength of not less than 80,000 pounds per square inch, or with two round wire straps 1/4 gage with tensile strength of not less than 100,000 pounds per square inch. The tensile strength of the joint for flat bands and round wires shall be at least 75% of the tensile strength of the strapping. The flat or round wire straps shall be applied over the sides, top and bottom approximately 1/6 the distance from each end of the box.

Liners - Either of the following moisture-proof liners will be acceptable; (1) Double crepe liners, the outer liner being not less than 45-pound basis and 60 percent heavily saturated paraffin and the inner liner being not less than 25-pound basis and 15 percent regular paraffin. (2) Outer liner of 90-pound crinkled duplex paper made of two sheets of 30 pound kraft paper joined together with an even layer of asphaltum and inner liner of not less than 25-pound basis and 15 percent regular paraffin. The liners shall be tied separately as closely to the ends as is practical to close securely.

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